



Wiring Assembly Instructions

M02P025M - Contact, ITA-Power, 25 Amp, Solder.



Fig. A. (Contact Sub-Assembly)

Contact Crimp Information Table

Wire Type	Wire Awg.	Strip Length In Inches	Crimp Tool	Hex Die Set/ Positioner	Indicator	Selector No.	Heat-shrink Length x Dia.
Stranded	18	A) 1/4"	N/A	N/A	N/A	N/A	5/8 X 3/16
	16	B) 1/4"					
	14	C) 1/4"					
	12	D) 1/4"					

Pull Test Values	
18 Awg	32lbs
16 Awg	39lbs
14 Awg	48lbs



(Values based on M22759/11xx)

(Example of Equipment)

NOTE 1: Refer to **IPC/WHMA-A-620A** standard (Ch. 11.1.2) for cable lengths, measurements and tolerance.

NOTE 2: Overall length of cable should be less 3/8" to compensate for the contact attachment.

STEP 1) Strip wire to dimensions in "Contact Crimp Information" Table using a ruler along with a wire stripper as shown in **Fig. B.**



Fig. B

STEP 2) Tin stripped wire. (This prevents wire strands from fraying) as in **Fig. C.**



Fig. C.

STEP 3) Put contact in a fixture, insert wire in contact and solder per **IPC/WHMA-A-620A** standard (Ch. 4.9.6) for Solder Connections – Cup Terminals.

NOTE: Inspect after insertion of wire into contact to make sure no strands of wire is protruding outside the Cup of the contact.

STEP 4) Remove and inspect Contact, making sure there is no spillage of solder over it and meets all standards set in **IPC/WHMA-A-620A** standards. **Fig. D.**



STEP 5) Slide Heat-Shrink over completed Assembly for Strain Relief, **Fig. E** below.



NOTE: Shrink-tube is to provide strain-relief and exposed solder joint.